



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3310
Job Sheet 168020



Part No: 646.3310

Job Qty: 8 ea

Part Name: LH Half - Upper Cutter Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Due Date: 11/27/17

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Heli Welders Canada (CHWEL01)

Building 47, Unit #1, 21330 56th Avenue Langley, BC, V2Y 0E5 Canada ph:(604) 530-5225

Note: DWG REV A IPP REV:A NEW ISSUE 12/11/17 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		11/24/17	0.00	0.00	Start Up Container		SS
110	CNC Vertical Machining	8 pcs		11/27/17	0.44	10.53	HAAS 1		SS
120	QC	8 pcs		11/27/17	0.00	0.00	QC2		SS
130	QC	8 pcs		11/27/17	0.00	0.00	QC8		SS
140	Outsource	8 pcs		11/27/17			ATG001-VC		SS
150	Packaging	8 pcs		11/27/17	0.00	0.00	Packaging2		SS
155	QC	8 pcs		11/27/17	0.00	0.00	QC5		SS
180	Packaging	8 pcs		11/27/17	0.00	0.00	Packaging3		SS
190	QC21-SA	8 Ea		11/27/17	0.00	0.00	QC21		SS

Part Op 110 - 1-Machine per folio FB154 Blank 13.375

Descriptions: 140 - Issue P/O to ATG : 1- Black Anodize as per Dwg 646.3300

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

38553

DEC 04 2017

DAS
13
2-29

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6B7.000X2.000	9	0	0	0

8.92 ft.

Part Specifications

Specifications could not be found.

5016112

Plex 11/30/17 4:09 PM dart.willems.sian

DART
AEROSPACE
S016301

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



LH Half – Upper Cutter Assembly

PART NO: 646.3310

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 12/01/17

Job No: 168020



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3310
Job Sheet 168020



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90	Start up Operation	8 Ea		11/24/17	0.00	0.00	Start up container		
110	CNC Vertical Machining	8 pcs		11/27/17	0.44	10.53	HAAS 1		
120	QC	8 pcs		11/27/17	0.00	0.00	QC2		
130	QC	8 pcs		11/27/17	0.00	0.00	QC8		Ex 17-12-4
140	Outsource	8 pcs		11/27/17			ATG001-VC		
150	Packaging	8 pcs		11/27/17	0.00	0.00	Packaging2		
155	QC	8 pcs		11/27/17	0.00	0.00	QC5		
180	Packaging	8 pcs		11/27/17	0.00	0.00	Packaging3		
190	QC21-SA	8 Ea		11/27/17	0.00	0.00	QC21		

Part Op 110 - 1-Machine per folio FB154 Blank 13.375

Descriptions: 140 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 646.3300

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 11/9/17 3:08 PM dart.lacelle.linda

Handwritten signature/initials

DART
AEROSPACE
S016301

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

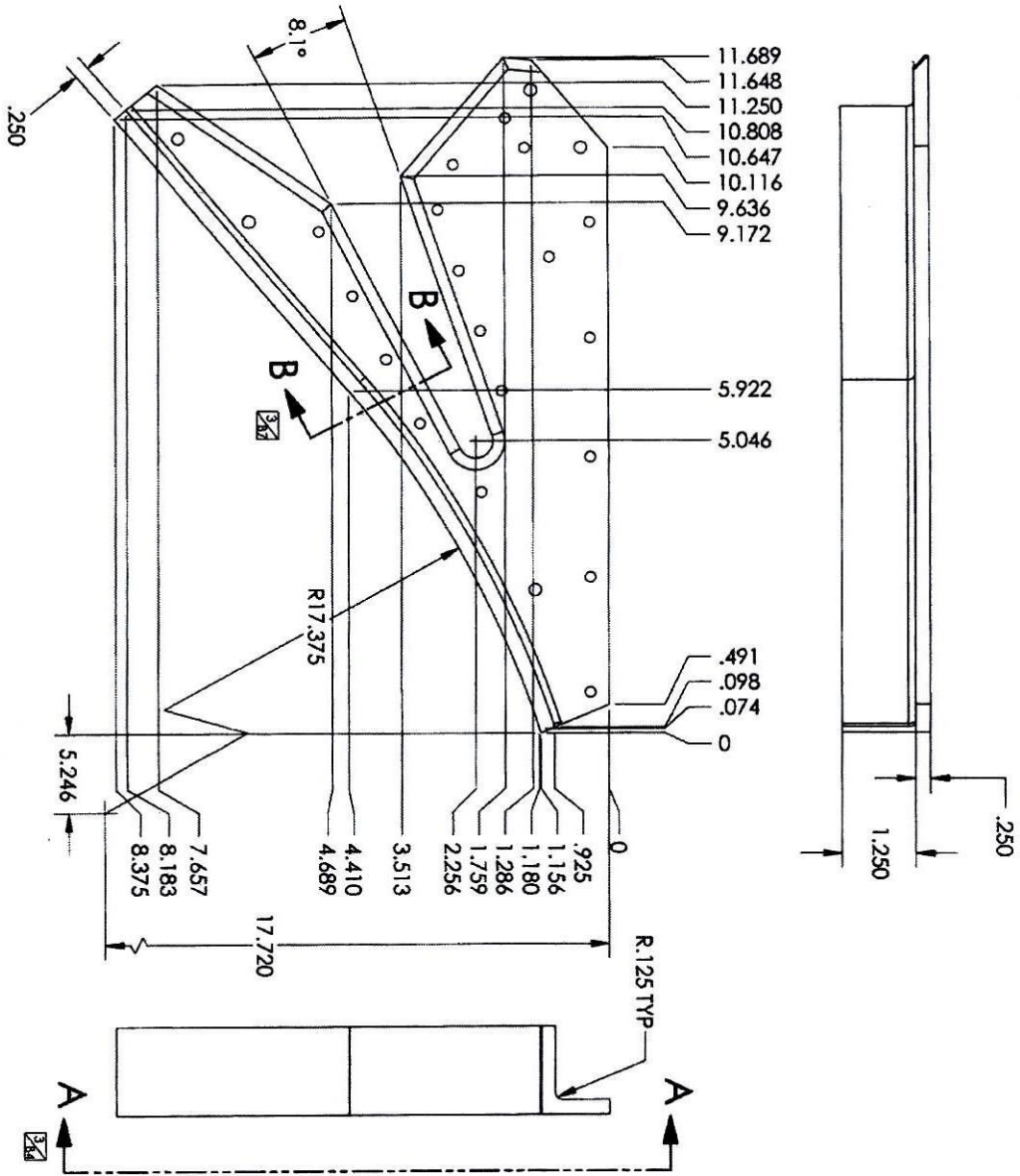


LH Half – Upper Cutter Assembly

PART NO: 646.3310
Revision:
Operation: Outsource
Change No:

Mfg Date: 12/01/17 Job No: 168020
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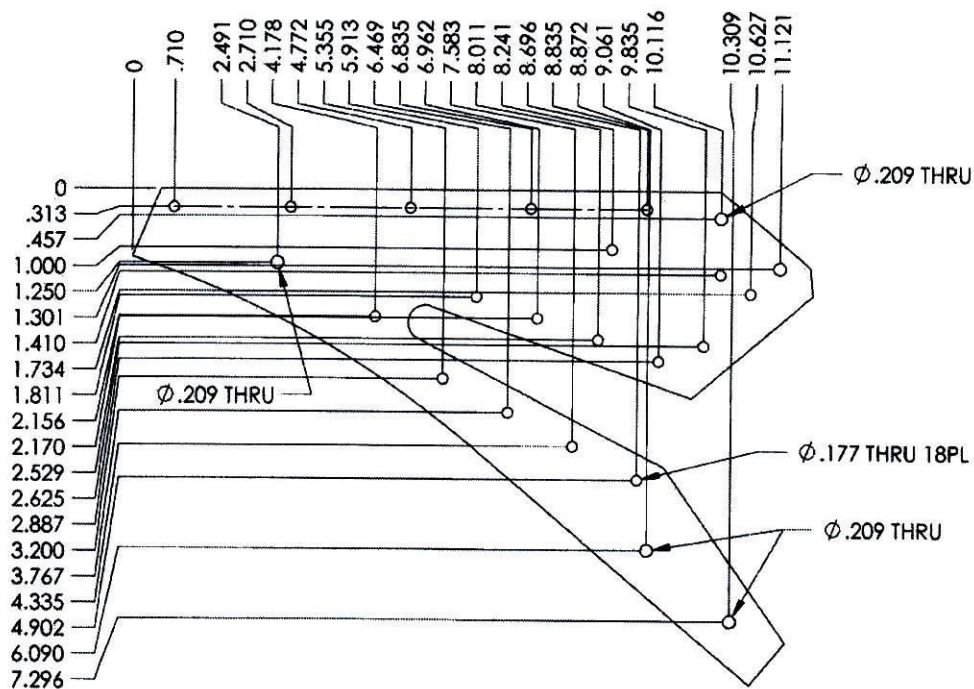
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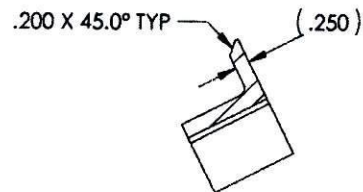
646.3310 SHOWN
646.3311 OPPOSITE

ORIGINAL DATE 08/04/04		3000 ENTERPRISE CT.	
DRAWN BY: J. B. BAKER		SHEET 1 OF 2	
CHECKED BY: J. B. BAKER		APICAL INDUSTRIES	
P. BAKER		APICAL INDUSTRIES	
CONTRACT NO.		APICAL INDUSTRIES	
INSTRUMENTS USED		APICAL INDUSTRIES	
FOLLOWING DATA FOR		APICAL INDUSTRIES	
1. PART NO. 646.3310		APICAL INDUSTRIES	
2. PART NO. 646.3311		APICAL INDUSTRIES	
3. PART NO. 646.3312		APICAL INDUSTRIES	
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161. PART NO. 646.3470		APICAL INDUSTRIES	

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SECTION A-A



SECTION B-B

ORIGINAL DATE REV. DATE 08-24-08		3030 ENTERPRISE CT. SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY S. HUBB	CHECKED P. BRAVO	DART AEROSPACE AFICAL INDUSTRIES, INC. DART AEROSPACE	
DRAWING APPROVAL		UPPER CUTTER ASSY	
CONTRACT NO.		SHEET B	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		DWG. NO. 646.3300	SCALE NONE
		SHEET 3 OF 8	

DART AEROSPACE LTD		Work Order: 168020
Description: L.H. Half		Part Number: 646.3310
Inspection Dwg: 646-3300 Rev: 10/18 A		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.296	± 0.005	7.298	✓		H.G.	
3.767	± 0.005	3.769	✓		H.G.	
0.457	± 0.005	0.459	✓		H.G.	
0.313	± 0.005	0.315	✓		H.G.	
0.710	± 0.005	0.710	✓		H.G.	
6.469	± 0.005	6.469	✓		H.G.	
10.116	± 0.005	10.116	✓		H.G.	
10.309	± 0.005	10.309	✓		H.G.	
Ø 0.177	$\pm 0.005/-0.001$	0.177	✓		G.P.	
Ø 0.209	$\pm 0.005/-0.001$	0.209	✓		G.P.	
0.250	± 0.005	0.252	✓		Mic.	
1.250	± 0.005	1.250	✓		Ver ED-6	
R 0.125	± 0.005	R 0.125	✓		R.G.	
3.513	± 0.005	3.513	✓		H.G.	
8.375	± 0.005	8.375	✓		H.G.	
0.250	± 0.005	0.252	✓		Ver ED-6	
8-1°	$\pm 0.5°$	8°	✓		D.A.F.	
11.689	± 0.005	11.689	✓		H.G.	
11.250	± 0.005	11.250	✓		H.G.	
0.200 x 45°	± 0.005	0.200 x 45°	✓		Ver ED-6 + D.A.F.	

Measured by: SC. / mpf	Checked by: F.X.	QC Inspector:
Date: 17/12/01	Date: 17-12-01	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038553**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038553
PO Date: 12/4/17
Due Date: 12/11/17
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169053	RBT18650-101-1	Drain Tool : URF17-660 -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2 WATER SEAL -Certificate of Conformity is required	Firmed	12/11/17	1 pcs	0 pcs	1 pcs	\$16.00/pcs	\$16.00
Line Item Note part RUSH										
2	168550	RBD29905-1	Side Plate -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	12/11/17	4 pcs	0 pcs	4 pcs	\$16.00/pcs	\$64.00
3	168575	RBD29905-3	Cord Handle -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	12/11/17	1 pcs	0 pcs	1 pcs	\$16.00/pcs	\$16.00

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	168574	RBD29905-15	Center Plate -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	12/11/17	5 pcs	0 pcs	5 pcs	\$16.00/pcs	\$80.00
5	167512	D5355-041	Aft Clamp Assembly Issue P/O to ATG : Black Anodize as per Dwg D5355 Certification of Conformity is required.	Firmed	12/11/17	4 pcs	0 pcs	4 pcs	\$5.61/pcs	\$22.44
6	166975	D4977-1	Bracket, LH Issue P/O to ATG : Hard Black Anodize, PRIME AS PER dwg D4977	Firmed	12/11/17	2 pcs	0 pcs	2 pcs	\$10.90/pcs	\$21.80
7	168020	646.3310	LH Half - Upper Cutter Assembly Issue P/O to ATG : Hard Black Anodize/prime as per Dwg 646.3300	Firmed	12/11/17	7 pcs	0 pcs	7 pcs	\$20.45/pcs	\$143.15
8	168226	646.3310	LH Half - Upper Cutter Assembly Issue P/O to ATG : Hard Black Anodize/prime as per Dwg 646.3300	Firmed	12/11/17	4 pcs	0 pcs	4 pcs	\$20.45/pcs	\$81.80
9	169137	646.3310	LH Half - Upper Cutter Assembly Issue P/O to ATG : Hard Black Anodize/prime as per Dwg 646.3300	Firmed	12/11/17	1 pcs	0 pcs	1 pcs	\$20.45/pcs	\$20.45
10	165562	646.9710	Body Issue P/O to ATG : Hard Black Anodize/prime as per Dwg 646.9700	Firmed	12/11/17	40 pcs	0 pcs	40 pcs	\$16.85/pcs	\$674.00
11	165646	646.9810	Deflector Issue P/O to ATG : Hard Black Anodize/prime as per Dwg 646.9800	Firmed	12/11/17	4 pcs	0 pcs	4 pcs	\$49.60/pcs	\$198.40
Grand Total:									\$1,338.04	

Order Notes

Order Notes

DWG RBT18650-101 Rev B IPP Rev B 17.11.29 DWG Rev B DP Verify DD

DWG RBD29905 Rev 5 IPP Rev A 17.11.15 New issue DP Verify DD

DWG RBD29905 Rev 5 IPP Rev A 17.11.15 New issue DP verify DD

DWG RBD29905 Rev5 IPP Rev A 17.11.15 New issue DP Verify DD

DWG REV D SHEET 1 IPP REV: A NEW ISSUE JFS 13/11/22 VERIFY BY: JLM IPP REV:B 14.06.16 AS PER DWG REV.C DD
VERF:JLM IPP REV:C RQ 16.09.07 DWG. REV: D VERIFIED BY: JLM

DWG REV A IPP REV:A NEW ISSUE 12/11/17 JFS VERIFY BY: JLM

DWG REV A IPP REV:A NEW ISSUE 12/11/17 JFS VERIFY BY: JLM

DWG REV A IPP REV:A NEW ISSUE 12/11/17 JFS VERIFY BY: JLM

DWG REV D2 SHEETS 2, 3, 4 IPP REV:A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

DWG REV A SHEETS 1,2,3 IPP REV:A NEW ISSUE 13/04/01 JFS VERIFIED BY:DD

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit
www.dartaerospace.com for further explanation.

Plex 12/6/17 10:06 AM dart.lavoie.chantal



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914308

Date: 15-Dec-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: 646.9710 Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 22105		Rev: D PO: PO038553 Line: 10
4 ea	Part: D5355-041 Aft Clamp Assembly Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils) Job: 22100		Rev: C PO: PO038553 Line: 5
7 ea	Part: 646.3310 LH Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22102		Rev: N/C PO: PO038553 Line: 7
4 ea	Part: 646.3310 LH Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22103		Rev: N/C PO: PO038553 Line: 8
1 ea	Part: 646.3310 LH Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22104		Rev: N/C PO: PO038553 Line: 9
Made in Canada.			

Made in Canada.



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